

Work Order ID 121686

Thursday, June 26, 2014 3:06:55 PM

121686

Page 1

Item ID: D3619-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Grommet

Start Date: 6/26/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/26/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: CL Date: 14/06/30 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3619 | Rev A |

100 PURCHASING 0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24811 Purchase Part Number: 9610K18 Supplier: MC
MASTER CARR Certificate of conformity is required

CL 14/06/30 (10)

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

14/6/2 (10)

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo

0.00

Quality Control

5MP
14/7/2

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 121686

Thursday, June 26, 2014 3:06:55 PM


121686

Page 2

Item ID: D3619-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Grommet
 Start Date: 6/26/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/26/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|--------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | Packaging | | | | | <u>10X</u> | <u>DAS</u> | <u>JUL 03 2014</u> | |
| Packaging | Memo | 0.00 | | | | | <u>28</u> | | |
| Packaging | ****Remove supplier paperwork from box.***** Identify and StockLocation: _____ | | | | | | <u>9-89</u> | | |
| 140 | | 0.00 | | | | | | | |
| *140* | QC21- Final Inspection - Work Order Release | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

ML5 1407-04


DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

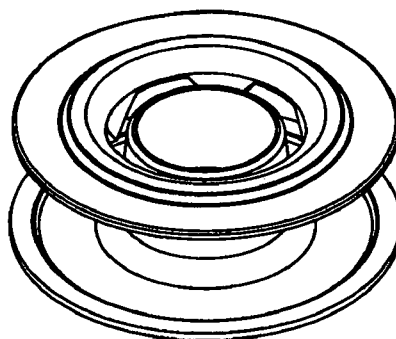
FAULT CATEGORY

| | | | |
|--|--|---|--|
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|--|--|---|--|



| | | | |
|----------------------|--------------------------------|--|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>LE</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3619 | REV. A SHEET 1 OF 1 |
| DATE 07.03.26 | | TITLE GROMMET | SCALE NTS |
| REV A | DATE 07.03.26 | DESCRIPTION NEW ISSUE | |

SPECIFICATION CONTROL DRAWING



RELEASED
07 04 02 #

CL 14/06/30
WFO: 12/686

D3619-X GROMMET,
WHERE X REPRESENTS THE GROMMET TRADE SIZE

| DART P/N | TRADE SIZE | DESCRIPTION | HOLE SIZE | MAX. MTL THICKNESS | MCMaster CARR P/N |
|----------|------------|------------------------|-----------|--------------------|-------------------|
| D3619-0 | 0 | BRASS GROMMET W/ TEETH | 1/4 | 0.110 | 9610K16 |
| D3619-1 | 1 | BRASS GROMMET W/ TEETH | 9/32 | 0.120 | 9610K17 |
| D3619-2 | 2 | BRASS GROMMET W/ TEETH | 3/8 | 0.150 | 9610K18 |
| D3619-3 | 3 | BRASS GROMMET W/ TEETH | 7/16 | 0.230 | 9610K19 |
| D3619-4 | 4 | BRASS GROMMET W/ TEETH | 1/2 | 0.300 | 9610K21 |

NOTES:

1) PURCHASE INFO: MCMaster-CARR P/N'S INCLUDE THE FOLLOWING:

48 GROMMETS FOR SIZE 0 & 1,
24 GROMMETS FOR SIZE 2, 3 & 4,
D3619-XT1 HOLE PUNCH,
D3619-XT2 STRIKER BLOCK,
D3619-XT3 PUNCH AND
D3619-XT4 DIE

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24811**

Purchase Order Date 6/30/2014

PO Print Date 6/30/2014

Page Number 2 of 4

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

| | | | | | | |
|---|---------|---------|----------|-------|---------|------------|
| 3 | 9610K18 | GROMMET | 7/2/2014 | 10.00 | \$13.31 | \$133.10 ✓ |
| | | | Yes | Each | | |
| | | | 7/2/2014 | | | |

AS PER DWG D3619 REV.A
B121686

Line Total: \$133.10

| | | | | | | |
|---|---------|----------------|----------|-------|--------|------------|
| 4 | 8672K31 | UHMW U-Channel | 7/2/2014 | 40.00 | \$3.26 | \$130.40 ✓ |
| | | | Yes | f | | |
| | | | 7/2/2014 | | | |

AS PER DWG D4287 REV. A
B121391

Line Total: \$130.40

| | | | | | | |
|---|----------|----------------|----------|-------|--------|------------|
| 5 | 71400-40 | 9381T24 S HOOK | 7/2/2014 | 50.00 | \$4.06 | \$203.00 ✓ |
| | | | Yes | Each | | |
| | | | 7/2/2014 | | | |

50 BOX OF 25 PCS

Line Total: \$203.00

Deliver To: FINISHING

Note:

6/30/2014

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Order Placed By
Chantal Lavoie

06/30/2014

McMaster-Carr Number
5763028-03

| Line | Description | Ordered | Shipped | LNS A83 | |
|------|---|--------------|---------|------------------------------|---|
| 1 | 6605K56 Hook and Loop Cable Tie, Black Flame-Retardant Wrap Around, 24" L, 3/4" Width, Packs of 5 Your Part Number: B121427 | 6 Packs | 6 | 3 - 125 - 11 43 - 39 K56 6PK | 1 |
| 2 | 9776K93 Flame-Retardant Hook and Loop, 1" W X 75' L, Adhesive Back, Beige, Lengths of 75 Your Part Number: B121596 | 4 Lengths | 3 | 1 - 459 | 2 |
| 3 | 9610K18 Military Specification Grommet Kit, with Teeth Washer, Trade Size 2, 3/8" ID, 24 Grommets Your Part Number: B121686 | 10 Each | 10 | 1 - 315 | 3 |
| 5 | 9381T24 Zinc-Plated Steel Open End S-Hook, 1/8" Diameter, 28# Work Load Limit, Packs of 25 Your Part Number: 71400-40 | 50 Packs | 50 | 3 - 293 | 5 |
| 6 | 2733A44 Cobalt Steel Wire Gauge Size Chucking Reamer, 30 Wire Gauge, 7/8" Flute Length, .1190" Shank Diameter Your Part Number: 71500-30 | 3 Each | 3 | 2 - 500 | 6 |

Dart Aerospace Ltd

EXP
INV
NAFTA



30 lbs
7 lines

Lg

38x12x12

FW1BSP20
06/30/2014
13:41/13:47
227
Cycle 48

1141173278945

